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| <b>Anziehvorschrift für Zylinderkopf</b>                                                                                                                                           |                                                                                                                                     | <b>831.638</b>                                                                             |  |
| <b>Tightening Instructions for Cylinder Head</b>                                                                                                                                   |                                                                                                                                     |                                                                                            |                                                                                   |
| <b>Instructions de serrage pour culasse</b>                                                                                                                                        |                                                                                                                                     |                                                                                            |                                                                                   |
| <b>Prescripciones de apriete para culatas</b>                                                                                                                                      |                                                                                                                                     |                                                                                            |                                                                                   |
| Schraubenkopf / Head shape<br>Tête de vis / Cabeza de tornillo                                                                                                                     |                                                                                                                                     | passend für / suitable for<br>adaptable à / adaptable a<br><b>Opel</b><br><br>Das Original |                                                                                   |
| Anziehreihenfolge/Tightening sequence/Ordre de serrage/Orden de apriete                                                                                                            |                                                                                                                                     |                                                                                            |                                                                                   |
|                                                                                                   | <div><div>⑧</div><div>④</div><div>①</div><div>⑤</div><div>⑨</div><div>⑦</div><div>③</div><div>②</div><div>⑥</div><div>⑩</div></div> |                                                                                            |                                                                                   |
| 820.458<br>M 11 x 140                                                                                                                                                              |                                                                                                                                     |                                                                                            |                                                                                   |
| Anziehen/<br>Tightening/<br>Serrage/<br>Apriete                                                                                                                                    | 1,8 l N / S / E / SE<br>* 25 Nm<br>➤ 60°<br>➤ 60°<br>➤ 60°<br>★ 15 min<br>➤ 30°                                                     | 1,8 l C 18 NT/ NE<br>* 25 Nm<br>➤ 60°<br>➤ 60°<br>➤ 30°<br>★ 15 min<br>➤ 30°               |                                                                                   |
| Zeichenerklärung / Explanations / Explication / Explicacion                                                                                                                        |                                                                                                                                     |                                                                                            |                                                                                   |
| ✱                                                                                                                                                                                  | neue Zylinderkopf-schrauben verwenden                                                                                               | use new cylinder head bolts                                                                | utiliser des vis neuves                                                           |
| ★                                                                                                                                                                                  | Warmlauf (80°C)                                                                                                                     | warm up time (80°C)                                                                        | chauffage (80°C)                                                                  |
| ☐                                                                                                                                                                                  | Schrauben einzeln lösen und wieder anziehen                                                                                         | loosen and tighten each bolt                                                               | deserrer et serrer vis par vis                                                    |
| ●                                                                                                                                                                                  | Setzzeit                                                                                                                            | relaxation time                                                                            | durée de tassement                                                                |
| ➤                                                                                                                                                                                  | Drehwinkel                                                                                                                          | torque angle                                                                               | angle de serrage                                                                  |
| Motortyp / Engine type / Type de moteur / Tipo de motor                                                                                                                            |                                                                                                                                     |                                                                                            |                                                                                   |
| 84, 8 Ø                                                                                                                                                                            |                                                                                                                                     |                                                                                            |                                                                                   |
| Mot. N, S, E, SE, NT, NE (OHC),<br>1,8 l, 55/66/85 kW (75/90/115 PS),<br>C 1,8 NT/NE, 4 Cyl.<br>Ascona-C, Kadett-D, Kadett-E, Rekord-E,<br>Manta-B,, Manta-GT, Kadett-GT/E, Astra, |                                                                                                                                     |                                                                                            |                                                                                   |
| ElringKlinger AG, Max-Eyth-Str.2<br>72581 Dettingen / Erms. Tel. 07123/724 601                                                                                                     |                                                                                                                                     | *831.638*                                                                                  |                                                                                   |